DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018670
Date Inspected: 01-Dec-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1500
OSM Departure Time: 300
Location: ShangHai, China

CWI Name: Tian Lei

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1
This QA Inspector observed the following work in progress for Bay 21.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Ju Lin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail
PCMK: 20TR2-041-013
Welder: 216575
Report: B-WR 16947
WPS-345-FCAW-2G (2F)-Repair

PCMK: 20TR2-044-009
Welder: 216872
Report: B-WR 17750
WPS-345-FCAW-2G (2F)-Repair

Heat straightening of PCMK, E2-SB1D-030, under approved Heat Straightening procedure, HSR 1(B)-9389, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ju Lin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 2
Heat straightening of PCMK, SA3445-001, under approved Heat Straightening procedure, HSR 1(B)-9810, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ju Lin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 7mm.

Bay 3
This QA Inspector observed the following work in progress for Bay 3.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Ju Lin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Segment Assembly
PCMK: SEG3019K-001-191,194
Welder: 055564
WPS-B-T-2233-ESAB

PCMK: SEG3019K-001-213,216
Welder: 044790
WPS-B-T-2233-ESAB

Bay 7
This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhu Jun Jie.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Cross Beam
PCMK: CB3003J-002-031,032
Welder: 055795
WPS-B-P-2114-FCM

PCMK: CB3003D-001-014~046
Welder: 215083
WPS-B-P-2113-Padeye

Bay 8

This QA Inspector observed the following work in progress for Bay 8.
ZPMC was using the Shield Metal Arc Welding (FCAW) process.
ZPMC QC is identified as Li Jia.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Bike Path
PCMK: BK004A-058
Welder: 058009
WPS-345-SMAW-3G (3F)-Repair

Bay 10
This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; BK004ASD1-026, on item number 1 of NWIT tracker document # 07579

Bay 14
This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; SEG3013U, on Item number 2 of NWIT tracker document # 07580,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
No relevant conversations
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for

your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer